

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020719**Date Inspected:** 10-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007E

Weld No: 192

WR: 19468

Welder: 068924

WPS-345-SMAW-1G(1F)-FCM-Repair

PCMK: SEG-3007V

Weld No: 447 and 459

Welder: 044772

WPS-3B-P-2114-FCM-1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Xie Ming Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007AX

Weld No: 009

Welder: 050242

WPS-B-T-2233-ESAB

Bay 14 East

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Xie Ming Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019AP

Weld No: 004

Welder: 215993

WPS-B-T-2221-B-L2C-S-2

Bay 16

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 16;

BP-3095-001 and BP-3101-001

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay 19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 19;

BK-004A-014, BK-004A-013, BK-004B-001, BK-005A-002, SB-108E, SB-106E, and SB-106W.

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay 28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Girder (OBG) a total of approx. 150 +/- Splice Plates for U-Ribs at this location in bay 28;
This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
